Work Order ID 101711

101711

May-13-13 1:12:30 PM

Item ID: D3121-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 5/13/13 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 5/31/13 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 13-05-14 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3121	Rev E								
100		0.00							
100	BAND SAW								
Bandsaw	**Memo**	0.00				4	0		
Jeaspa Bandsaw	Cut blanks: (1.000" x 2.000") 3.250" long								
110		0.00							DAS 08 9-89
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	**Memo**	0.00				4	0		
HAAS CNC vertical machine #1	1-Machine D3121-11 as per Folio FA331 and Dwg D3121Identify as D3121-112-Deburr3-Scribe batch number								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 08 9-89
120									
QC	**Memo**	0.00				4	0		
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 101711

101711

May-13-13 1:12:30 PM

Item ID: D3121-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 5/13/13 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 5/31/13 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130			FK 13/06/04			4	ø		
QC	**Memo**	0.00							
Quality Control									
140		0.00							
140	Small Fab					4K			13/06/04
Small Fab	**Memo**	0.00							
Small Fab	Assemble D3121-141 as per Dwg D3121.								
150	QC5- Inspect part completeness to step on W/O	0.00	WS 27						
150						4			
QC	**Memo**	0.00	B6.5						
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
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Work Order ID 101711

101711

May-13-13 1:12:30 PM

Item ID: D3121-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 5/13/13 **Start Qty:** 4.00 *4*

Required Date: 5/31/13 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST235	0.00			a	4x	N.C.	13-06-5	
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00					13/6/10		
170									
QC	**Memo**	0.00							
Quality Control									

RCB-06-4

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
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- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

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- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

May-13-13 1:12:29 PM

Work Order ID: 101711

Parent Item: D3121-041 **Start Date:** 5/13/13 **Required Date:** 5/31/13

Parent Item Name: Bracket Assembly **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP Rev:Pick:A04.02.18New issueKJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21 Bolt		Manufactured	No			140	Each	71.0000	1	4			
				Location		**Loc Qty**		**Loc Code**					
				ST235		71							
					99292	41							
					99601	30							
D3121-241 Bearing Assembly		Manufactured	No			100	Each	77.0000	1	4			
				Location		**Loc Qty**		**Loc Code**					
				FG		14							
					89826	4							
					95927	10							
				ST235A		63							
					98649	63							
M174B1.250X02.000 17-4 SS Bar 1.250 x 2.00		Purchased	No			140	f	11.7223	0.2705	**1.1389474**			
				Location		**Loc Qty**		**Loc Code**					
				MAT049		11.7223							
					114899	2							
					119231	2							
					123294	7.7223							

13/06/04

13/06/04

M125052

This Batch only 1.00 x 2.00 13.05.27

M12 1026 1.2

OK 13/05/26

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

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- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
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Supplier	☐									
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FAULT CATEGORY

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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD	Work Order:	101711
Description: Bracket	Part Number:	D3121-11
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	ϕ0.3930	✓		MIC	6A-03
Ø0.201 x 0.100	+/-0.010	ϕ0.200x0.100	✓		Vern	6A-01
0.75	+/-0.030	0.752	✓		"	"
0.375	+/-0.010	0.376	✓		"	"
1.250	+/-0.010	1.250	✓		H-6	31006
0.300	+/-0.010	0.300	✓		Vern	6A-01
1.96	+/-0.030	1.962	✓		"	"
Ø0.573	+/-0.010	ϕ0.573	✓		"	"
0.345	+/-0.010	0.345	✓		"	"
0.300	+/-0.010	0.298	✓		"	"
0.080	+/-0.010	0.080	✓		"	"
2.56	+/-0.030	2.560	✓		H-6	31006
2.14	+/-0.030	2.120	✓		Vern	6A-01
0.130	+/-0.010	0.134	✓		"	"
2.57	+/-0.030	2.566	✓		"	"
2.85	+/-0.030	2.850	✓		H-6	31006
0.381	+/-0.010	0.381	✓		Vern	6A-01
0.400	+/-0.010	0.394	✓		"	"
0.201	+/-0.010	0.199	✓		"	"
0.580	+/-0.010	0.580	✓		"	"
0.032	+0.000/-0.010	0.031	✓		D-6	6A-08

Measured by:	DAS	Audited by:	F.K.	Prototype Approval:	N/A
Date:	13/06/01 08 8-89	Date:	13/06/04	Date:	N/A

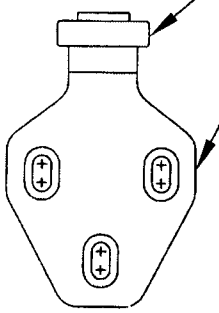
Rev	Date	Change	Revised by	Approved
A	08.02.01	New Issue P/O D3121-041	KJ/EC/DD	
B	08.06.02	Tolerance revised for Ø0.573	KJ/DD	

DART

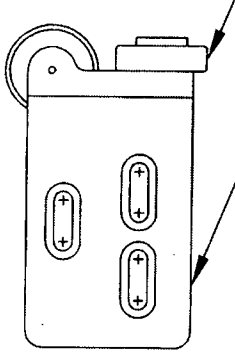
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

A	02.04.15	NEW ISSUE
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD −141/−143/−144/−145/−146
C	04.02.17	ADD CLEARANCE; USE −241 BEARING
D	06.05.17	D3121−25 CAP WAS 1.024, NOW 1.000
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)

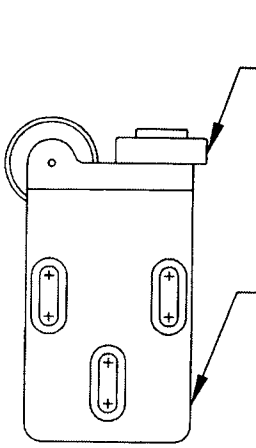
RELEASED
07.11.07



D3121−041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30−23000−33)

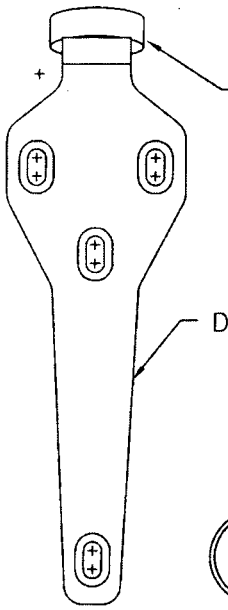


D3121−043 (SHOWN) / D3121−044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30−23000−37/−38)



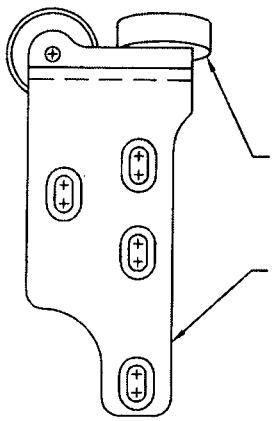
D3121−045 (SHOWN) / D3121−046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30−23000−35/−36)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

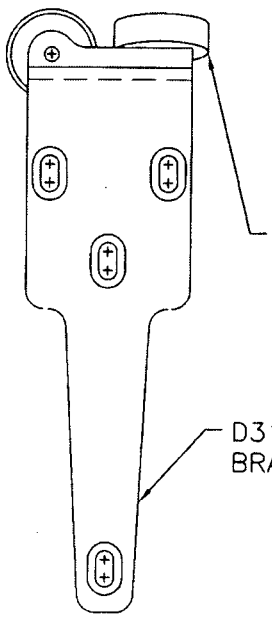


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07



D3121-143 (SHOWN) / D3121-144 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)

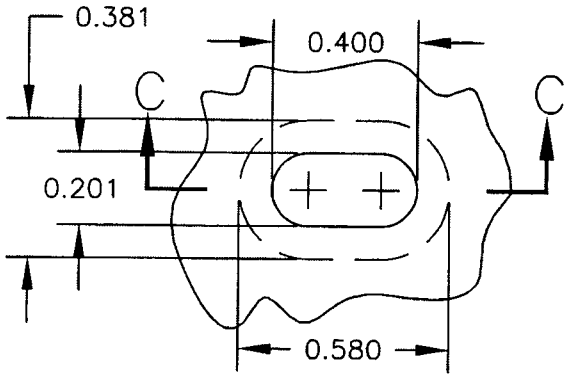


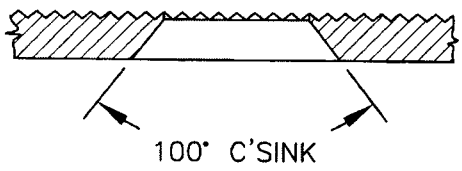
D3121-145 (SHOWN) / D3121-146 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

1674

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

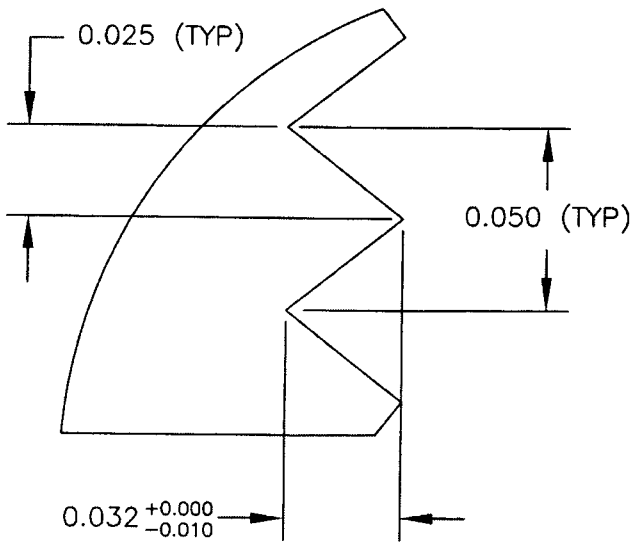




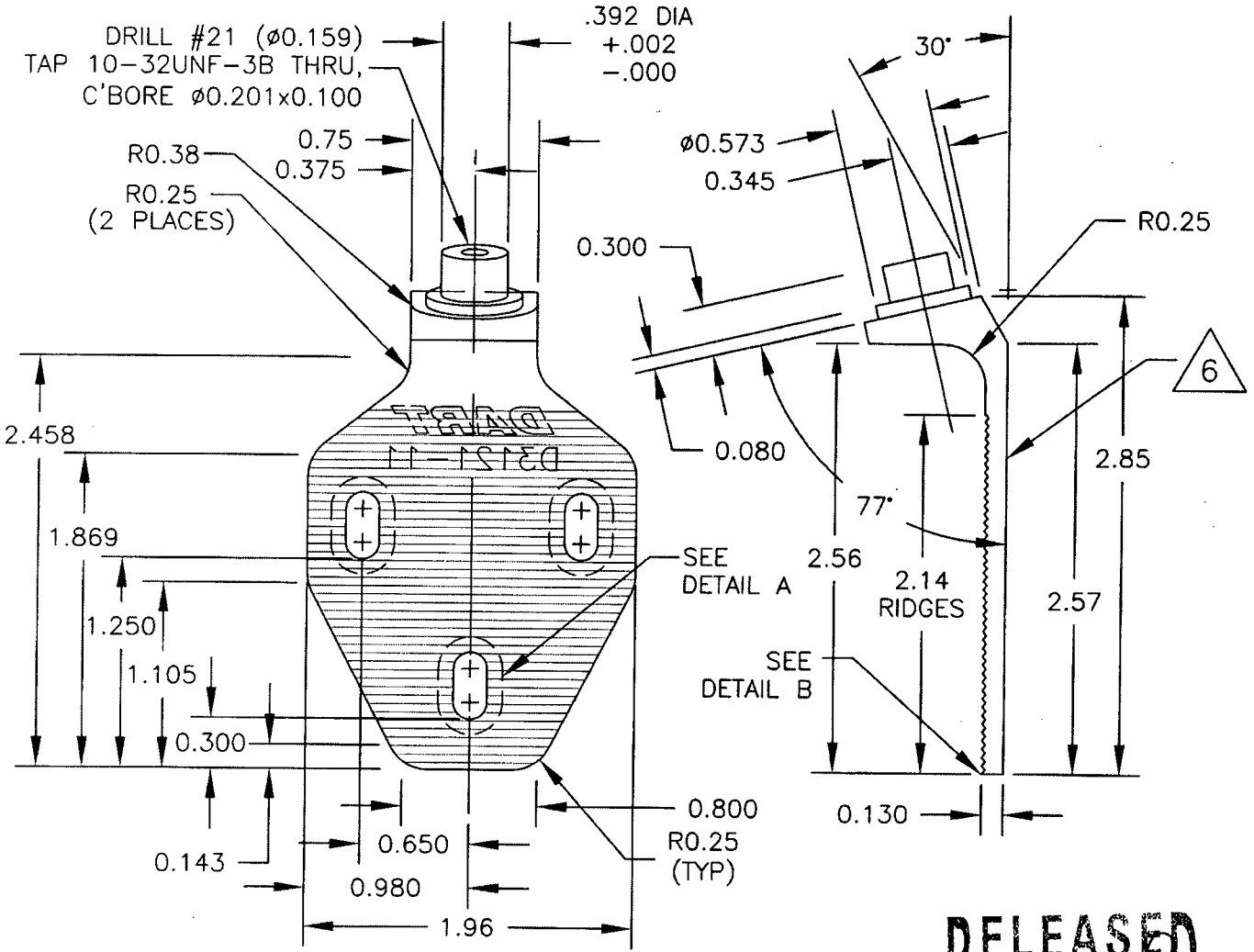
SECTION C–C

RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



RELEASED
07.11.07

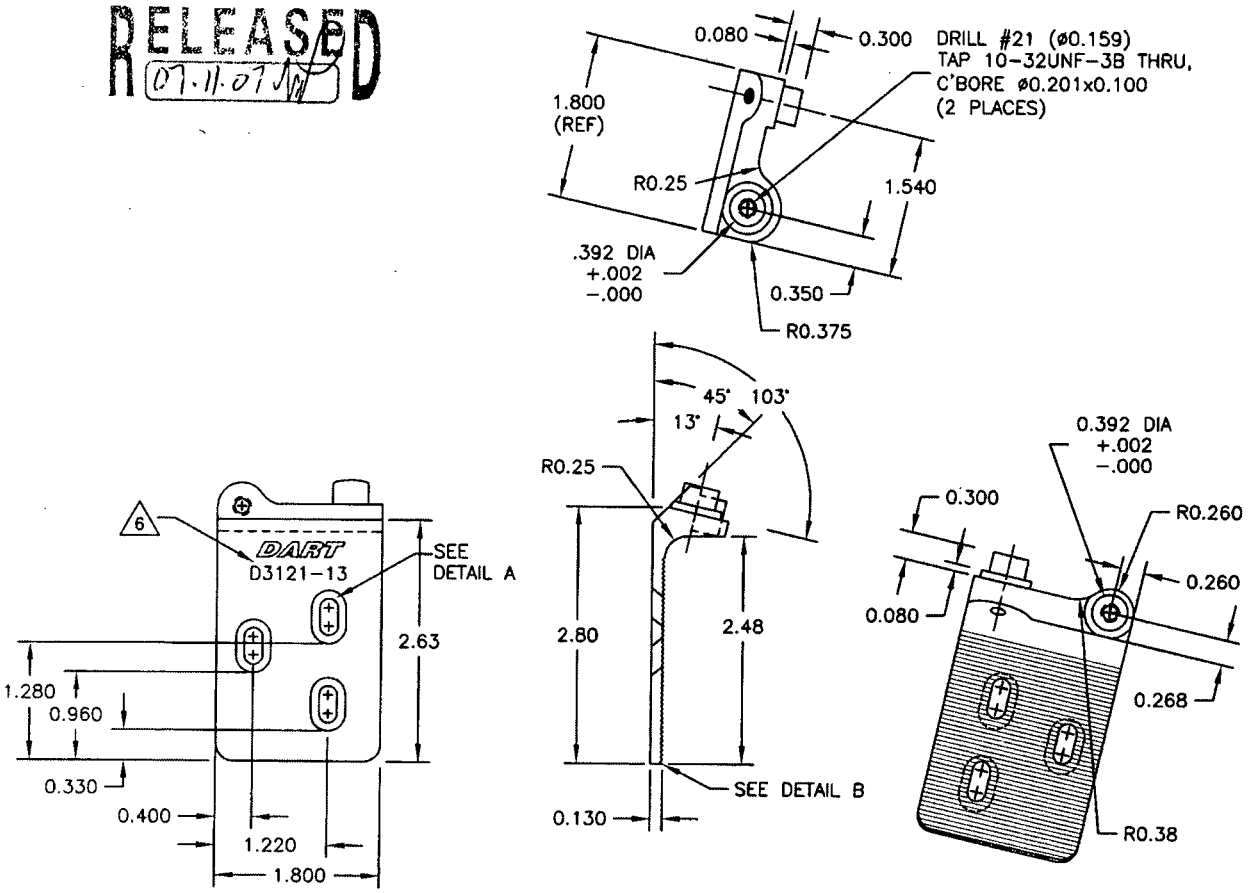
D3121-11 BRACKET

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

07.11.07

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



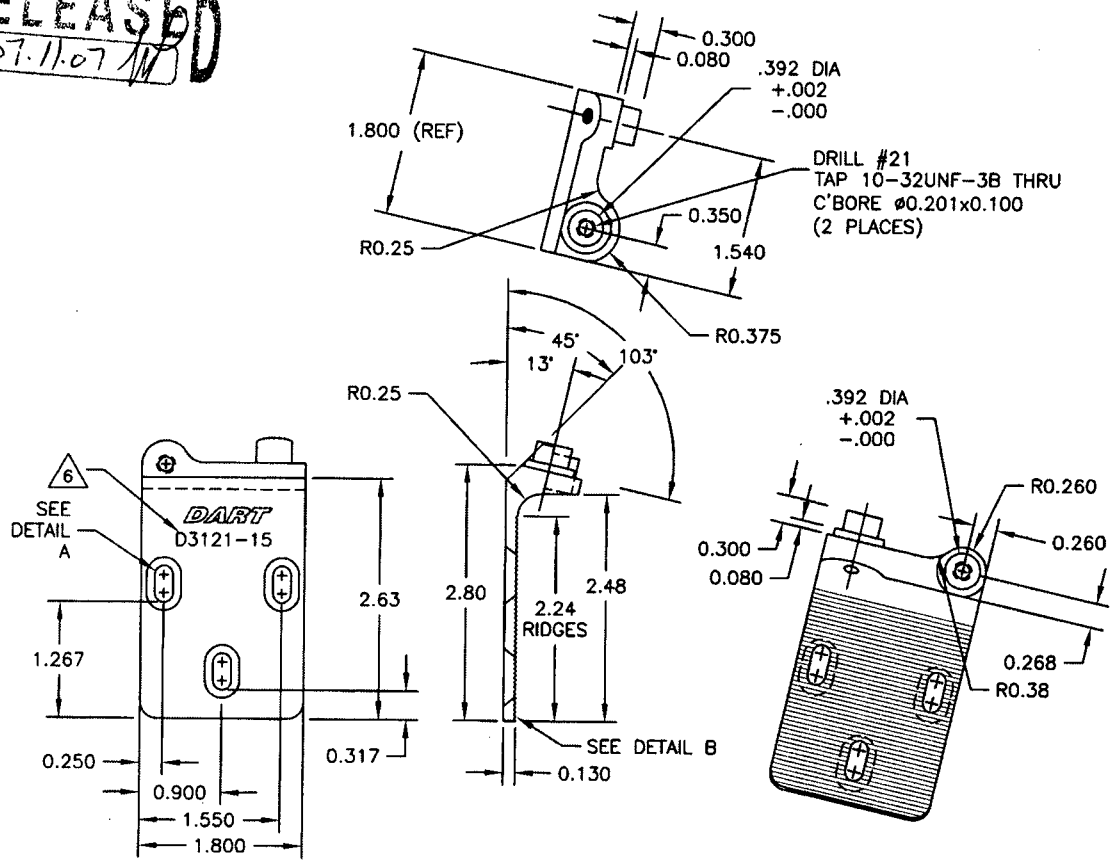
D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

114101

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



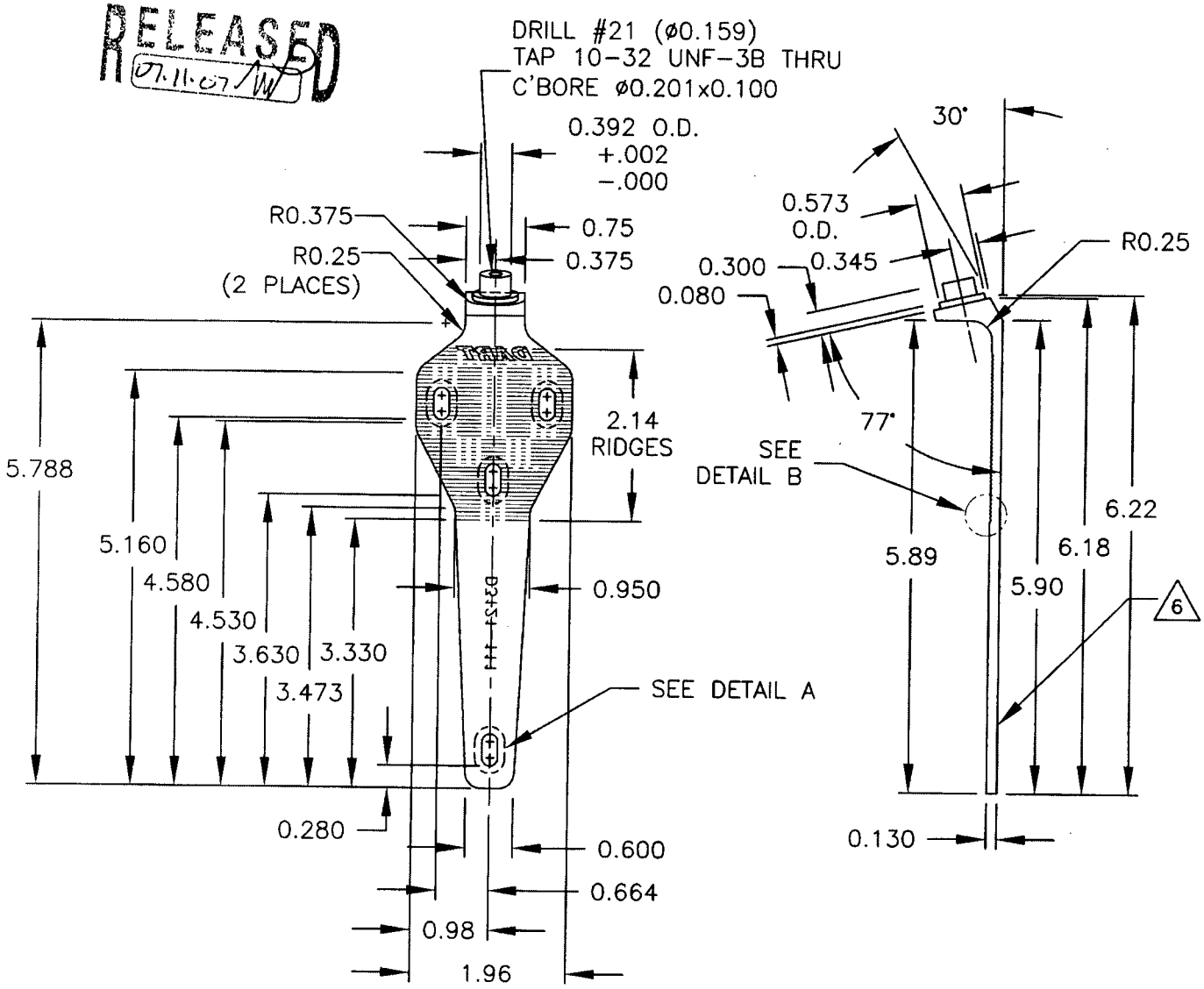
D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N AND LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

11 of 101

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07 JW



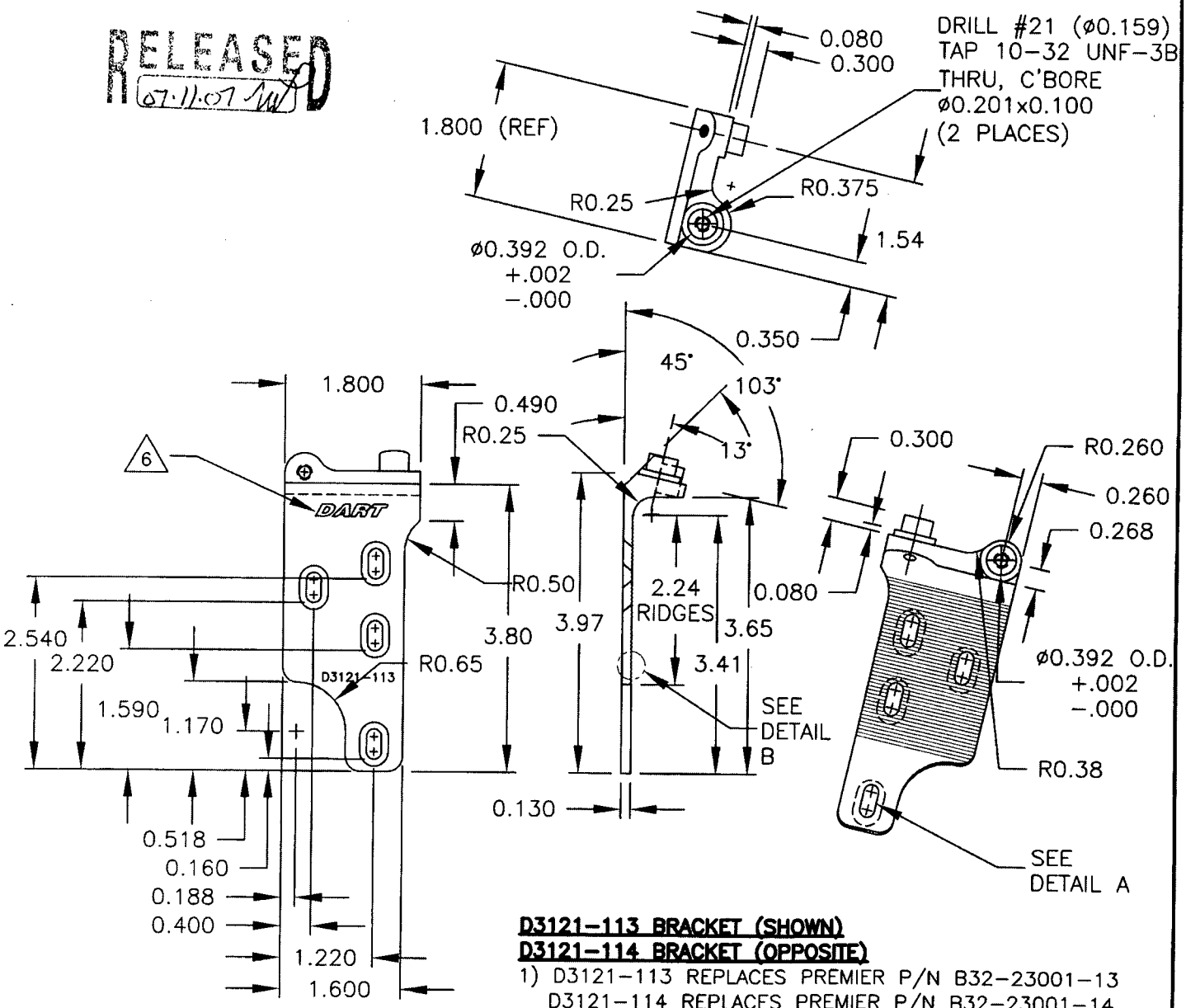
D3121-111 BRACKET

1) REPLACES PREMIER P/N B32-23001-11
2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

11701

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



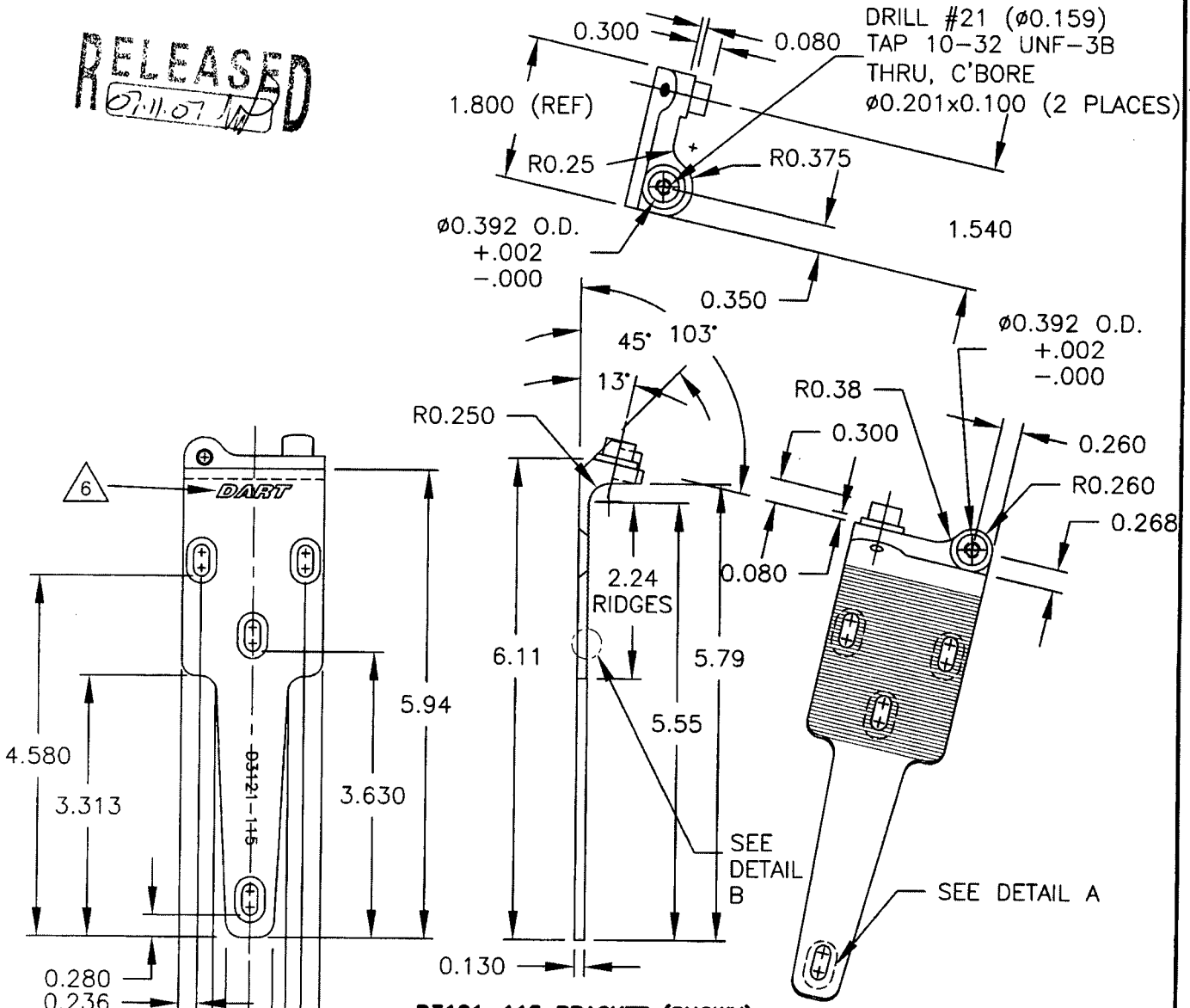
D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

1) D3121-113 REPLACES PREMIER P/N B32-23001-13
   D3121-114 REPLACES PREMIER P/N B32-23001-14
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

11/7/01

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

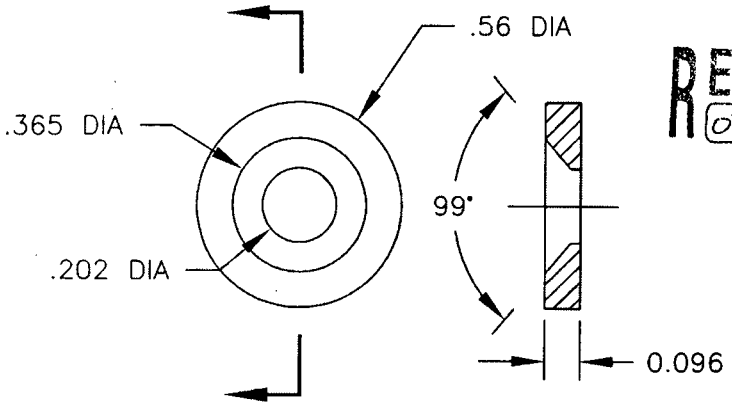


D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

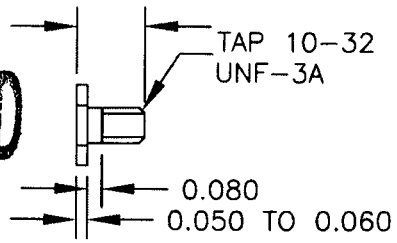
1) D3121-115 REPLACES PREMIER P/N B32-23001-15
   D3121-116 REPLACES PREMIER P/N B32-23001-16
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

11/07/07

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



RELEASED
07.11.07

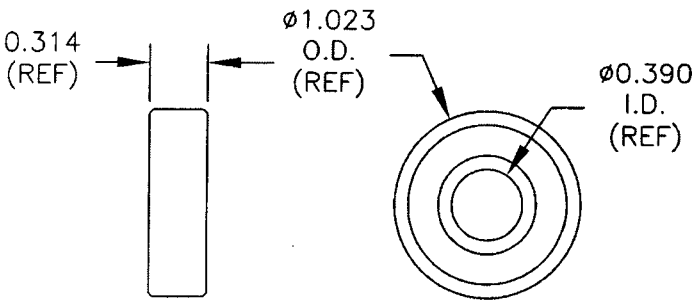


D3121-17 WASHER (SCALE 2:1)

1) REPLACES PREMIER P/N B32-23001-17
2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015

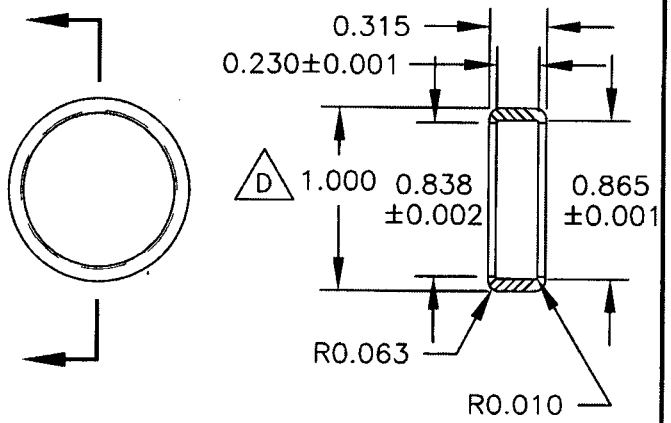
D3121-21 BOLT (SCALE 1:1)

1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



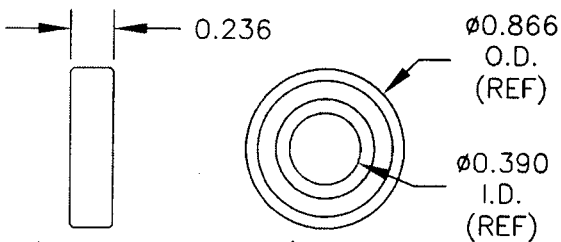
D3121-19 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
2) ALL DIMENSIONS ARE IN INCHES



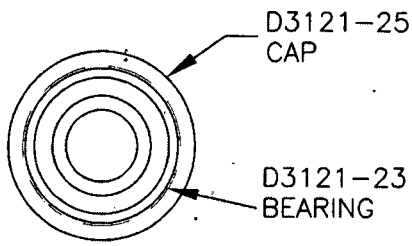
D3121-25 CAP (SCALE 1:1)

1) MATERIAL: DELRIN ROD, ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
2) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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